



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D205-634-141
Job Sheet 195707



Part No: D205-634-141

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: D205-634 REV.I/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead-Time	Sign-off
					Setup Hrs	Run Hrs		
110	Skidtubes - 1	1 pcs	7/5/19		0.00	2.00	Skidtubes - 1	
							Skidtubes - 2	
							Skidtubes - 3	
							Skidtubes - 4	
							Skidtubes - 5	
							Skidtubes - 6	
							Skidtubes - 7	
120	Skidtubes - Bend - 2 - B4B	1 pcs	7/5/19		0.00	1.00	Skidtubes - Bend - B4B	
							Skidtubes - 1 - B4B	
130	Skidtubes - 2 - B4B	1 pcs	7/5/19		0.00	2.00	Skidtubes - 2 - B4B	
							Skidtubes - 3 - B4B	
							Skidtubes - 4 - B4B	
							Skidtubes - 5 - B4B	
							Skidtubes - 6 - B4B	
							Skidtubes - 7 - B4B	
140	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	



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CANADA
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Container No: S187777



Part: D205-634-141

Job No: 195707

Serial No/Batch: S187777

Revision: H/I

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 2, FAA STC SR005631

Plex 5/30/19 9:01 AM Dart.Guerin.Kimberley

A27777RH
S187777RH

150 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 2.00	QC 5 - 30	
				QC 5 - 40	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	M66
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
160 QC 10	1 pcs	7/5/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	DAS
				QC 10 - 24	24
				QC 10 - 43	9-89
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
170 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.50	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
190 Powdercoat - 1 White Gl(A)-B4B	1 pcs	7/5/19	0.00 0.80	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
200 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	

JUN 1 1 2019

JUN 1 1 2019

JUN 1 2 2019

BEB 19-06-24

14-6-25

DAS
15
9-89

210 Handfinish - 3-1- WingWalk-B4B 1 pcs	7/5/19	0.00 1.33	QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			Handfinish - 3 - 1 - B4B	Jul 19 - 7-22
			Handfinish - 3 - 2 - B4B	
220 QC 5 1 pcs	7/5/19	0.00 0.00	Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	DAS
			QC 5 - 49	81
			QC 5 - 51	9-89
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
230 Packaging 3-1 - Stock - B4B 1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	SMB
			Packaging 3 - 8 - B4B	19/8/24
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
235 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	DC - 1 - B4B	AUG 26 2019
				DC - 2 - B4B	
240 QC 21 - FG	1 pcs	7/5/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

DAS
77
9-89
DAS
77
9-89

Part Op 110 - (Skidtubes)1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL
Descriptions: 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)
120 - (CNC Delta 100 Bender)1-Bend as per program D2580.C on CNC Bender and Folio FT 16
130 - (Skidtubes)1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Skidtubes)1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 13901/ 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR
160 - QC10- Inspect visual per QSI004- ground welds)
170 - QC5- Inspect part completeness to step on W/O) Production .0000 * Attachments 180 HandFinish And realodine tube as per QSI 005 HandFinish2 (Pressure Wash p
180 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)And realodine tube as per QSI 005
190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 12:45 TEMP: 320° FINISH: 1:20
200 - (QC3- Inspect Part Finish)
210 - (Assemble as per dwg)1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 51743422-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# 5185147
220 - (QC5- Inspect part completeness to step on W/O)Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024
230 - 1 (Identify as per dwg & Stock Location:)Identify and pack for shipping as per PPPD205-634-141 Location : FG084
235 - (Document Control)Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004
240 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - 1	5179507
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	150-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	24 pcs (24 ea)	150-Skidtubes - 3 - B4B	5154382
AN3-5A	Bolt	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5149158-1
AN4-45A	Bolt	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5103295
D2570	Bushing	16 pcs (16 ea)	210-Handfinish - 3-1- WingWalk-B4B	5194205-2
D2594-1	Plug	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5189085
D2594-3	O-Ring	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5173297
D2855	Cap	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5126188
D4406-041	Fwd Wearplate Assembly	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5190047
D4406-043	Aft Wearplate Assembly	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5198237
MS21042-4	Nut	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5158589
NAS1149D0332J	Washer	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5178378
				M.H. 010595

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2580-1	1	4	0
150-Skidtubes - 3 - B4B	D2576-3	1	47	0
210-Handfinish - 3-1- WingWalk-B4B	D4202-1	24	857	0
	AN3-5A	2	194	0
	AN4-45A	8	53	0
	D2570	16	85	0
	D2594-1	8	106	0
	D2594-3	8	411	0
	D2855	1	52	0
	D4406-041	1	1	0
	D4406-043	1	0	0
	MS21042-4	8	116	0
	NAS1149D0332J	2	3,596	0

Part Specifications
Specifications could not be found.

Plex 5/30/19 9:01 AM Dart.Guerin.Kimberley

ITEM	QTY -041	QTY -048	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2680-041	SKIDTUBE ASSEMBLY
2		X			D2680-045	SKIDTUBE ASSEMBLY
3			X		D2680-047	SKIDTUBE ASSEMBLY
4				X	D2680-046	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2680-1-100	EXTRUSION
21			16	16	D2670	BUSHING
22	1	1	1	1	D2678-3	STEP
23		4			D2679	SPACER
24	16	16	8	8	D2680-4	PLUG
25	16	16	8	8	D2684-3	O-RING
26	1	1	1	1	D2688	208 WEB
27	1	1	1	1	D2685	AFT CAP
28	1	1			D2684-5	WEARSHOE
29	1	1			D2684-9	WEARSHOE
30	1	1			D2684-11	WEARSHOE
31	1	1			D2684-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1	1	D4409-041	WEARPLATE ASSEMBLY
34				1	D4408-045	WEARPLATE ASSEMBLY
35				1	D2691-1	FRD WEARPLATE
36				1	D2691-3	AFT WEARPLATE
39	50	50			AL57-1032-130 or AN57-1032-130 or AN54-1032-130 or AEL5-1032-130	INSERT
41	50	50			AN50A	BOLT
42	2	2	2	2	AN5-5A	BOLT
43			8	8	AN4-45A	BOLT
44	50	50			NAS114903032R	WASHER (AN800C10L)
45	2	2	2	2	NAS114903032J	WASHER (AN800D10L)
46			8	8	M521062-4	NUT (CR M521062L4)

GENERAL NOTES:

- 1) MATERIAL: WA
- 2) FINISH: CHEMICAL CONVERSION PER DART CSI 005 4.1 PRIOR TO INSERTING D2680 WEB
POWDER COAT (F44-047-049) GLOSS WHITE (REF 4.3.1.1) PER DART CSI 005 4.3
POWDER COAT (F44) GREEN SANDTEX (REF 4.3.2.6) PER DART CSI 005 4.3
BLACK ANTI-SPRINT PAINT AS INDICATED PER DART CSI 005 4.4.
3) TOLERANCES: PER DART CSI 016 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES 0.06 TO 0.010 MAX.
6) IDENTIFICATION: NONE
7) WEIGHT: D2680-041 = 35.7 lbs
D2680-045 = 35.7 lbs
D2680-047 = 45.1 lbs
D2680-049 = 32.0 lbs
8) WELDING PER DART CSI 004
9) INSERT D2680 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SHOTEX-241 ADHESIVE PER DART CSI 016 BEFORE
BENDING. ENSURE HOLES LINE-UP
10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND
ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS
ALLOWABLE IN THE BENT PORTION OF THE TUBE
11) USE DART DRILL TEMPLATE DT8217 & DT8537 ONLY FOR D2680-041-046 TO LOCATE AND DRILL
Ø0.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-9 AND F-4 (Ø0
PLACES) AFTER FINISH. INSTALL AN50A BOLTS AND NAS114903032R WASHERS WITH
SHOTEX-241-251.
12) INSERT D2684-1 PLUG C/W D2684-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER
FINISH (6 PLACES FOR D2680-041-046 AND 8 PLACES FOR D2680-047-049)
13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2685 AFT CAP TO PREVENT INTERFERENCE WITH
THE SPACER AT THIS LOCATION

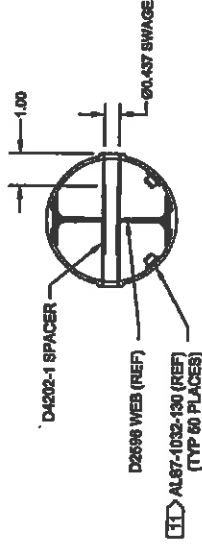
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2017 JUL 05
5647-559

H	SHEET: PL DELETE D2680-1454-13 GASKETS, WEIGHTS UPDATED ACCORDING X, SHEETS 2 & 4 FACTORYIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DST 0088	AJB	14.04.08
F	INCORPORATE DEO D2680-E-1 PER PART12-318	DC	13.09.20
E	ADD D2680-047 (ZN CA-7) AND D2680-7 (ZN BS-3R) INCLUDED DEO D2680-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8537 WAS TD2677-205 (ZN CA-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS,	PH	07.04.05
C	INCLUDE DEO 8124/8143	CP	06.06.26
B	REDRAWN, INCLUDED DEO 9804/9807	DS	06.12.02
A	AS MANUFACTURED	DS	06.06.16
REV.	NEW ISSUE	BY	DATE
DESIGN	DS	DESCRIPTION	
DRAWN	SAD		
CHECKED		DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
MPG, APPR.		DRAWING NO.	REV. H
APPROVED		D2680	SHEET 1 OF 9
DE APPR.		TITLE	SCALE
DATE	17.06.09	205 SKIDTUBE ASSEMBLY	NTS

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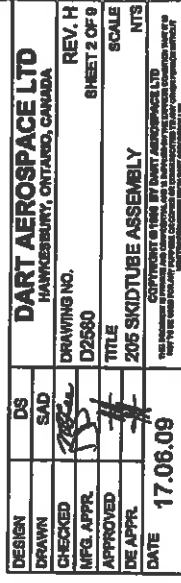


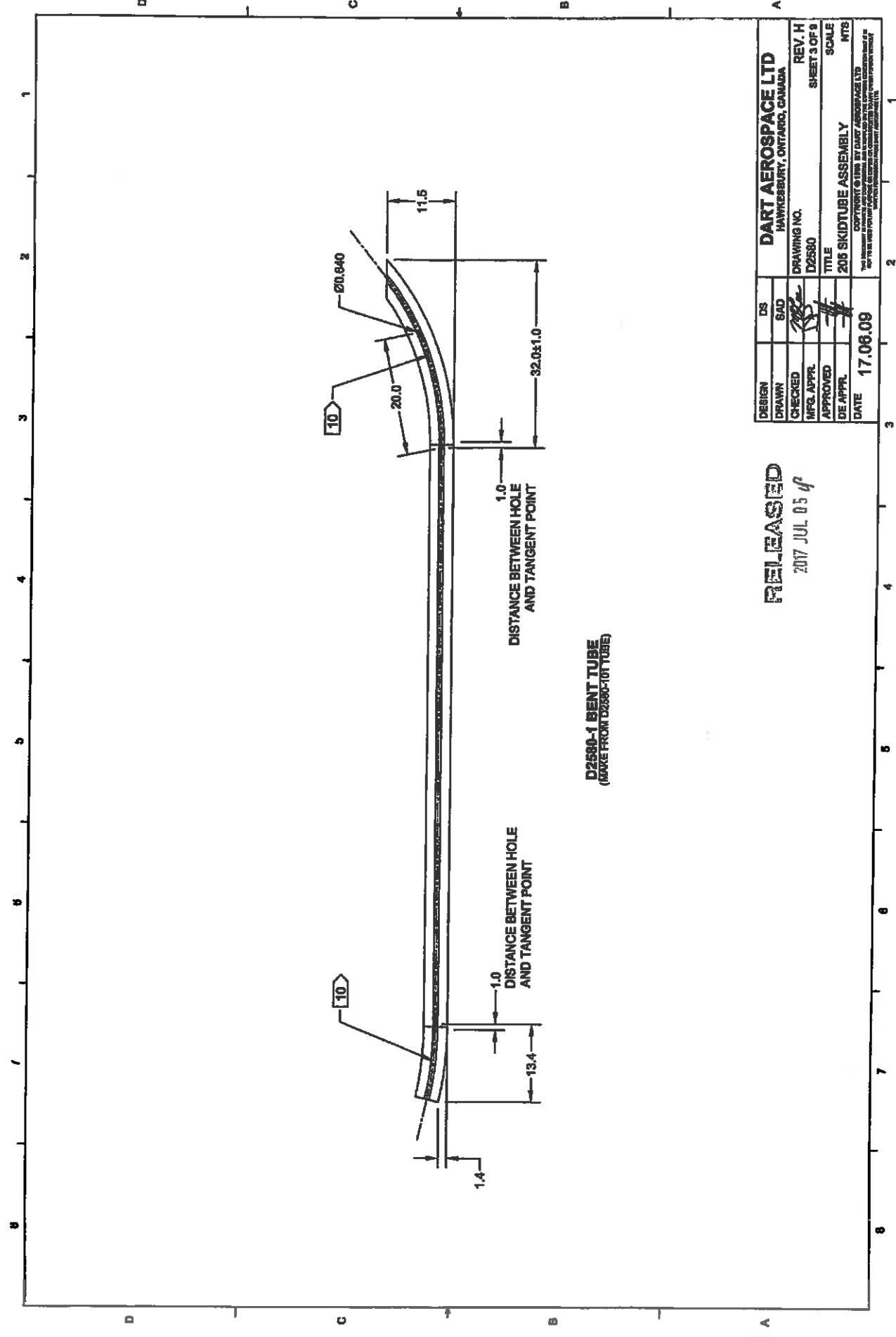
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SECTION B-B
SCALE 5X

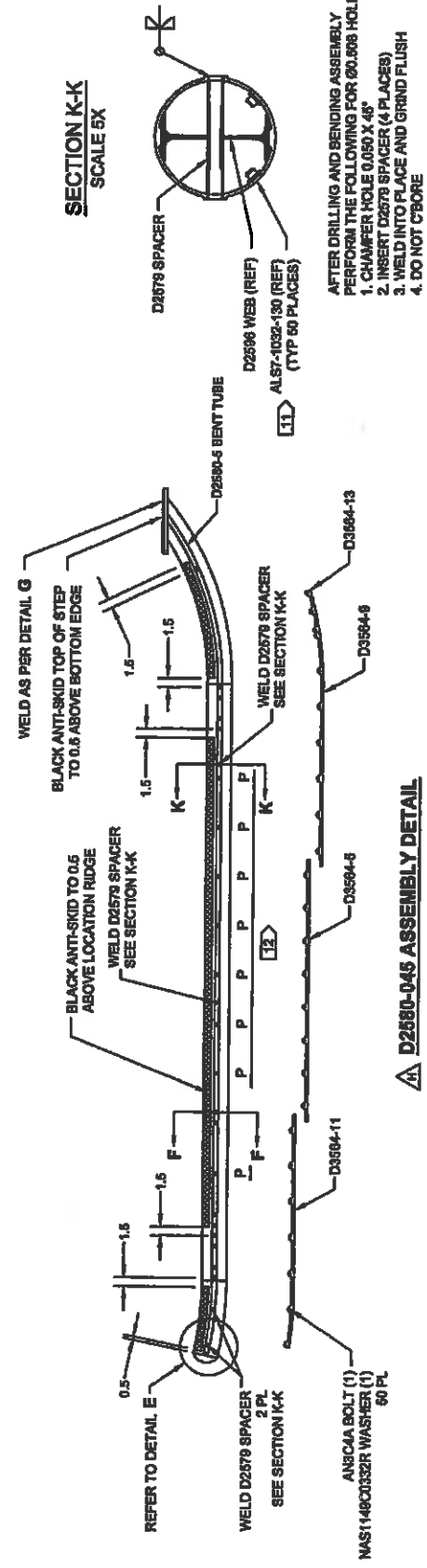




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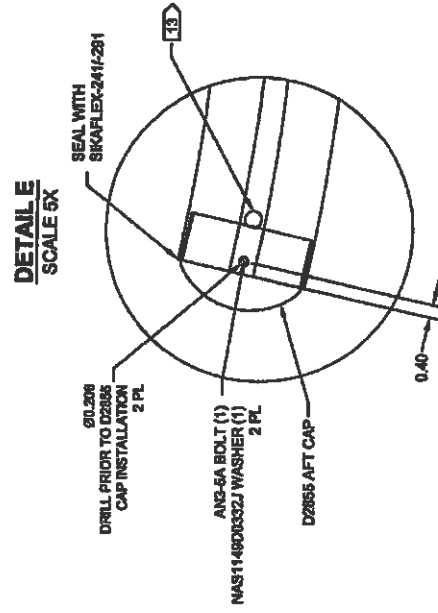
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DRAWN	SAD	
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. H
INFO. APPL.	<i>[Signature]</i>	D2580 SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE
DIE APPL.	<i>[Signature]</i>	206 SKIDTUBE ASSEMBLY SCALE
DATE	17.08.09	NTS

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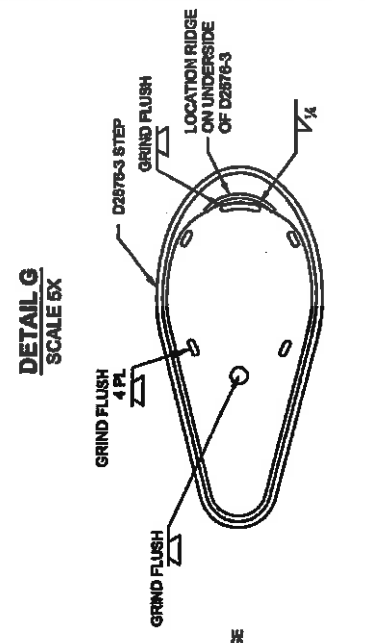
**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.808 HOLES ONLY:**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT CBORE



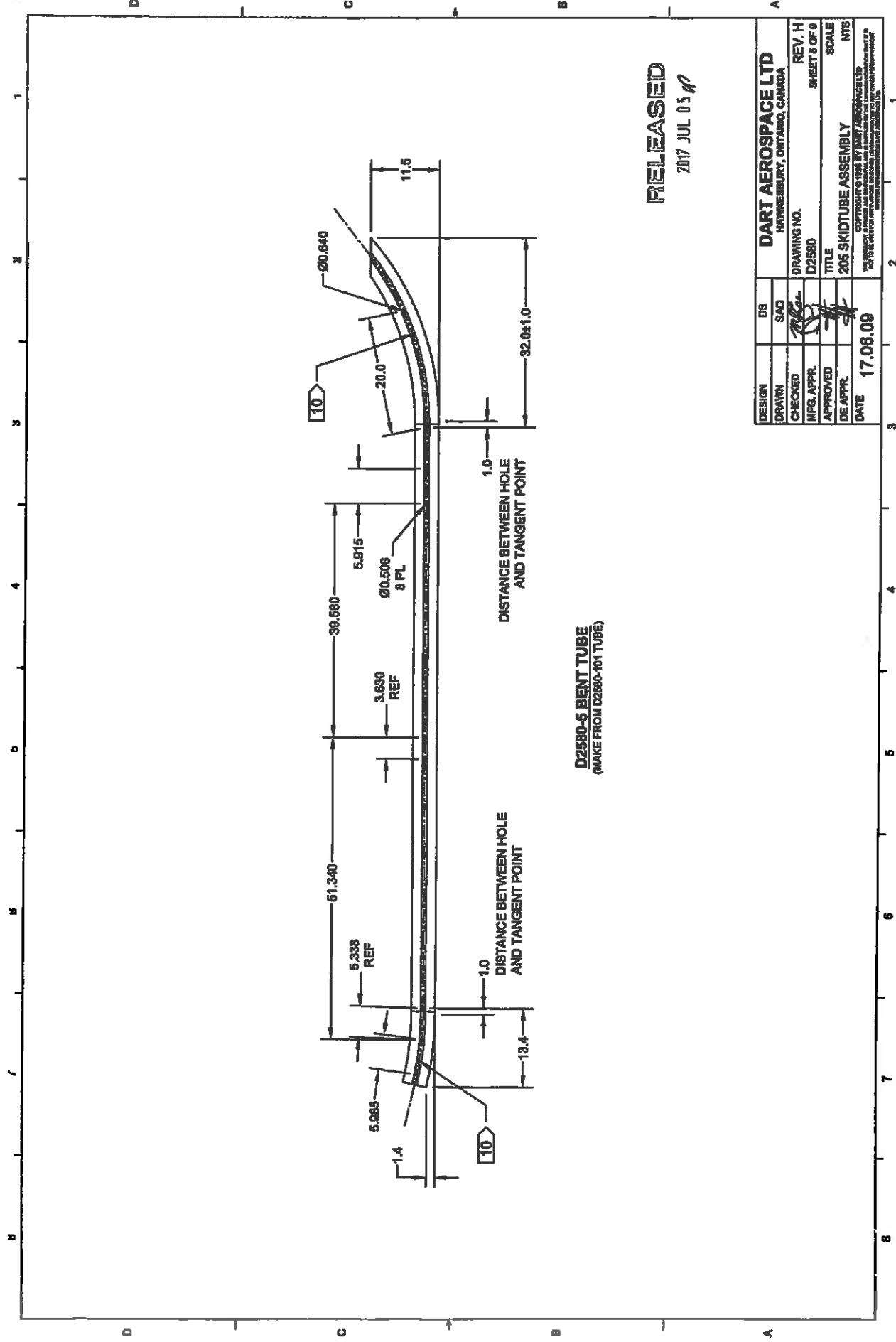
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PERFORM THE FOLLOWING FOR 60LB08 HOLES ONLY:**

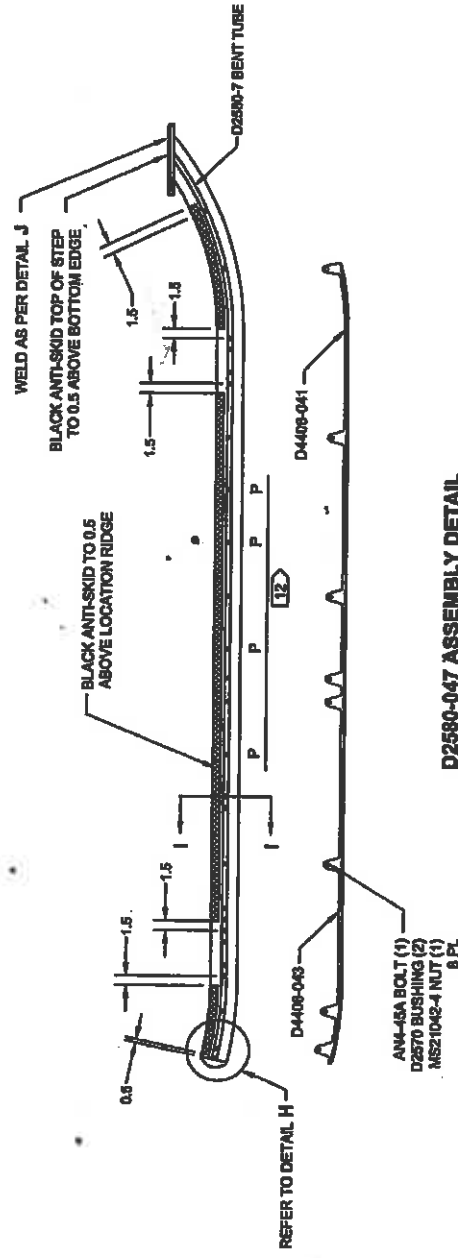
- 1. INSERT D4202-1 SPACER (20 FLAPS)**
- 2. SWAGE TO 60.437 X 1.00 DEEP PER Q81 002**
- 3. TRIM/GRIND FLUSH PER Q81 002**



DESIGN	DS	DART AEROSPACE LTD HAINESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 4 OF 9 SCALE NTS COPYRIGHT © 1987 BY DART AEROSPACE LTD NO REPRODUCTION OR TRANSMISSION OF THIS DOCUMENT OR ANY PART THEREOF WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD IS EXPRESSLY PROHIBITED
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MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DATE	17.06.09	TITLE 205 SKIDTUBE ASSEMBLY

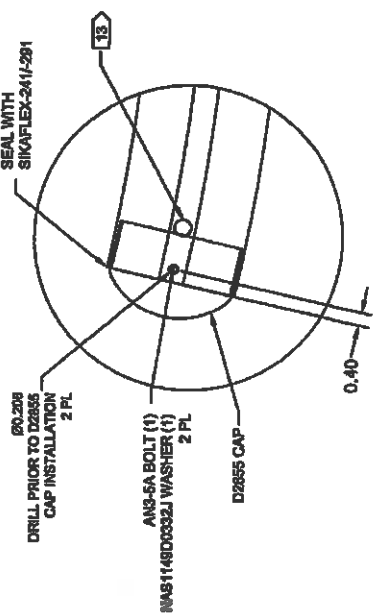
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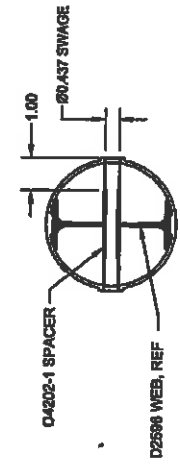


D2580-047 ASSEMBLY DETAIL

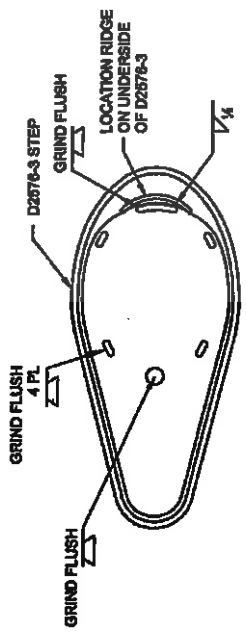
DETAIL H
SCALE 5X



SECTION H
SCALE 5X



DETAIL J
SCALE 5X

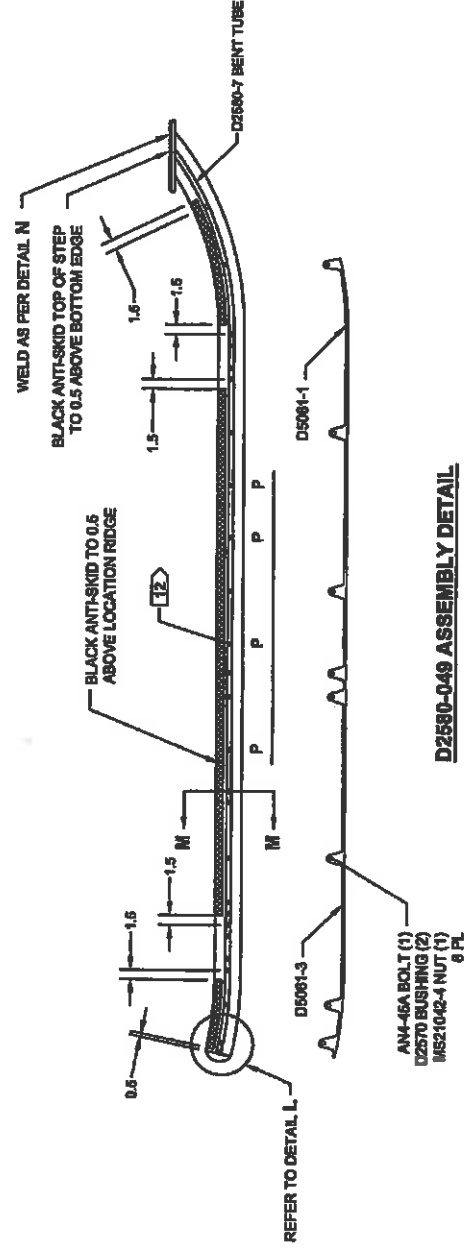


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4502-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER Q81 002
3. TRIM/GRIND FLUSH PER Q81 002

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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MFG. APPR.		
APPROVED		
DE APPR.		
DATE	17.06.09	

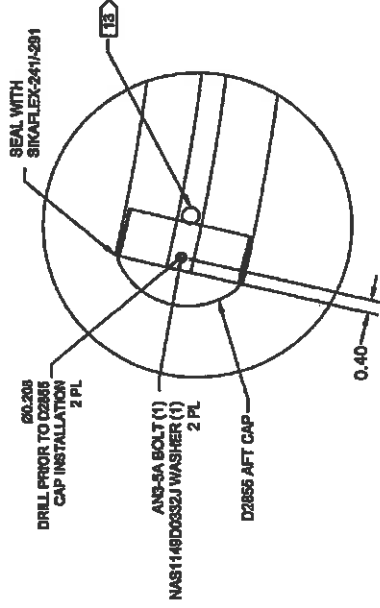
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REV. H	DART AEROSPACE LTD
DRAWING NO.	D2580
TITLE	205 SKIDTUBE ASSEMBLY
SCALE	NTS
NTS	

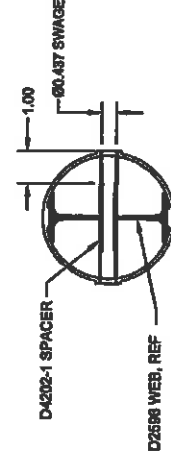


D2580-049 ASSEMBLY DETAIL

DETAIL L
SCALE 5X

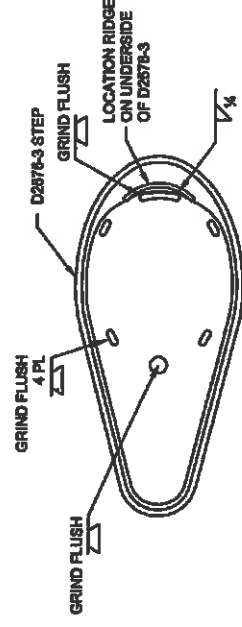


SECTION M-M
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER Q81 002
3. TRIM/GRIND FLUSH PER Q81 002

DETAIL N
SCALE 5X



DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	DRAWING NO. D2580
CHECKED		REV. H SHEET 7 OF 9
MFG. APPL.		TITLE
APPROVED		205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTB

RELEASED
2017 JUL 05 4p

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DESIGN	DS		DART AEROSPACE LTD HAYESBURY, ONTARIO, CANADA		
DRAWN	SAD				
CHECKED					
INFG. APPR.					
APPROVED					
DE APPR.		TITLE	206 SKIDTUBE ASSEMBLY	SCALE	INTS
DATE	17.06.09				

Change Record

Part Number: D205-634-141

PAGE 1 OF 1

Description: REPLACEMENT SKIDTUBE W/ TRAINING WEARPLATE

[illegible]